

Work Order ID 128502

Friday, January 16, 2015 2:50:07 PM

128502

Page 1

Item ID: D4775-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Assembly

Start Date: 1/22/15

Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/22/15

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 150120

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4775

C

110

Pick Kit

0.00

110

Large Fab

Packaging

Memo

0.00

Packaging

5FFFEB 2 5 2015

120

0.00

120

Small Fab

Memo

0.00

Small Fab

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 17130986

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

5FFFEB 2 5 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128502

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Page 2

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 1/22/15 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/22/15 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-88
130						5			FEB 26 2015
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>ST-574</u>	0.00							
140						5			
Packaging	Memo	0.00							FEB 28 2015
Packaging									DAS 03 0-10
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MLJ 15-02-27

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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128502

D4775-041

Required Date: 1/22/15

Required Qty: 5.00

AS PER REV.C DD VRF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	20.0000	1	5			
D4775-1									**			FEB 2 7 2015	
Strut Tube													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST514	129407		20			5			
					127707		20						
D4777-1		Manufactured	No			110	Each	26.0000	1	5			
D4777-1									**			FEB 2 7 2015	
Rod End Bearing													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST127	128451		26			4			
					127488		26			1			
D4776-1		Manufactured	No			110	Each	40.0000	1	5			
D4776-1									**			FEB 2 7 2015	
Basket Strut Clevis													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST126			40						
					127822		40			3			
D4776-5		Manufactured	No			110	Each	104.0000	4	20			
D4776-5									**			FEB 2 7 2015	
Spacer													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST127	128451		104						
					127743		104			20			

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FAULT CATEGORY

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Picklist Print

Friday, January 16, 2015 2:50:07 PM

Work Order ID: 128502

128502

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 1/22/15

Required Date: 1/22/15

Start Qty: 5.00

Required Qty: 5.00

AN3-10A Purchased No 110 Each 150.0000 2 10

AN3-10A

Bolt

FF

FEB 27 2015

Location	Loc Qty	Loc Code
GA	16	
m127817	16	
ST338a	134	
m130466	134	

10

MS21042L3 Purchased No 110 Each 2,045.000 2 10

MS21042L3

Nut

FF

FEB 27 2015

Location	Loc Qty	Loc Code
FP001	447	
M130922	447	
ST305	1595	
M130799	31	
M131264	1564	
ST307	3	
123900	3	

10

MS21209-F615 Purchased No 110 Each 89.0000 1 5

MS21209-F615

Heli-Coil

FF

FEB 27 2015

Location	Loc Qty	Loc Code
GA	89	
m131270	89	

5

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